

Minland Machine Inc.

DCB10 Setup Certification				
Machine Serial Number	20022		Machine Parameters As Shipped	
Date Tested	6.10.2010			
Initials	DRB		[AxisPPU]	[Network Settings]
VB Version	6		0PPU=11280	PC IP 192.168.72.20
DII Version	n/a		1PPU=61	ACR9000 IP 192.168.72.21
MotherBoard (SOYO)	MB800			Gateway 192.168.72.1
Motion Card (Type / Buss)	ACR9000		[SystemResolution]	
Operating System	WinXP Pro		0Resolution=0.000714332648	
TouchScreen Port	USB		1Resolution=0.0163940385	
AcroBasic Version	6			
Timer interval	100ms		[SwingArmParameters]	[StopTableParameters]
			MaxAcc=1000	MaxAcc=50
			MaxVel=300	ZeroOffset=231.875
			MaxBendAngle=183	Table_MAXTravel=222.6512
Homing Repeatability@10cycles	0.002	In.	ClampDelay=500	MaxVel=40
Positioning Repeatability	0.002	In.	UnclampDelay=0	Decel=30
Swing Arm Deviation@90	0.2	Degrees	ArmReturnDelay=300	ToolLength=24
24vdc Power Supply Voltage	24.2	Volts	LubeCounter=200	DefaultPositionMode=1
24vdc Supply Model (Keyence)	7.2	Amps	LubeTime=200	DefaultMetric=0
Main AC Power Type 220/440	440	Volts	swingArmFudge=0	AirStopDelay=0
Hydraulic Pres @ Guage	1000 max	PSI	PositionTolerance=.2	SlideClampDelay=300
Hyd Oil Temp @ 1 Hour Runtime	120	Degrees	DeCel=1000	RetractBeforeClamp=0
Air Pressure @ Guage	80 Min.	PSI	armHomeOffset=-.18	ForwardPBdelay=0
			ArmDacOffset=0	PositionTolerance=.002
			ArmReturnPos=.0	StopExtLength=3.5
[Machine Setup]			BendTimerLimit=5	StopClearance=4.125
Servo Amp (10 amp Allen Bradley)	AB2098DSD010		ArmReturnPercent=50	EnableExtendedStop=1
Servo Motor (Allen Bradley)	ABTLA220PHJ32AN		JogVel=30	StopsCountLimit=4
Gearhead Ratio	10:01		JogACC=1500	StopUnlockDwell=2
Servo Controller	9000P3U2M0		JogDec=1500	InPosTime=10000
Touch Screen (Planner New Style) 15"	LA1500LTR			TableError=0
[Gains0] Stop Table				HomeStopsIfStopCountChanged=1
PGAIN=0.003			[MachineOptions]	JogVel=10
IGAIN=0.5			SerialNo=20022	JogACC=1000
ILIMIT=0.5			TimerInterval=100	JogDec=1000
IDELAY=0			MandrelOption=0	
DGAIN=0.000001			IdleTime=60	
DWIDTH=0			Mandrel=False	
FFVEL=0			dxBackColor=12632256	
FFACC=0			drawBarFirst=True	
TLM=10			drawBarInJog=True	
			ScannerOption=False	
[Gains1] Swing Arm			RequirePartNo=False	
PGAIN=0.010000			TaskBarOFF=True	
IGAIN=0.100000			ForceHoldBendButtons=True	
ILIMIT=0.250000			defaultprogrampath=C:\20022 Bender\Program Files\	
IDELAY=0			ForceExplorerToUseDefaultPath=False	
DGAIN=0.000090				
DWIDTH=0				
FFVEL=0				
FFACC=0				
TLM=10				
			Bender Options	Notes:
			No Mandrel	Oiler Set to 2cc per shot (2sec Oil Time)
Lubrication			3 Button Console	Amp Setup File DCB10-2098-DSD-10.udb
Hydraulic Filter 10 Microns Min			3.5 " Stop Extention	Air Input Must be >= 80 psi or Stop locks will not work
Hydraulic Fluid (40 Gal Approx)	A/W 46 (Citgo)		440Vac 3ph. Main Power	
Way Lube System Oiler (Conaco)	Multi-Way Machine Lubricant			
Pneumatic oiler (Air System)(Conaco)	Velocite Oil #3			
Grease Fittings Grease (Citgo)	MP Lithplex		Bend Cylinder Fr. Chain Conn.	2.44 OAL.